UNITED STATES AIR FORCE ACADEMY SPECIFICATION USAFA CU 120-09

30 December 2002

COAT, SERVICE, CADET, MEN'S

COAT, CADET, MEN'S, SERVICE

1. SCOPE

- 1.1 <u>Scope</u>. This specification covers the requirements for service coats worn by male cadets at the United States Air Force Academy.
- 1.2 <u>Classification</u>. The coat shall be of the one type in the following classes (see 6.2).

Class 1: Stock

Class 2: Made to Measure

1.2.1 Lengths and sizes. The coats shall be furnished in the following lengths and sizes, as specified (see 6.2):

X-Short 33 | 34 39 40 43 44 Short Med. Reg 39 40 45 | 46 45 46 Regular Med. Long Long 51 52 X-Long XX-Long 39 40 45 | 46 51 | 52

Table I. Schedule of sizes (chest)

1.2.2 <u>Class 2 - Made to Measure</u>. The finished measurements of these coats will depend upon the result of the individual's measurements, which will be furnished by the government. (see 6.2)

2 APPLICABLE DOCUMENTS

2.1. Government documents

2.1.1. <u>Specifications, standards, and handbooks.</u> The following specifications, standards, and handbooks form a part of this document to the extent specified herein. Unless otherwise specified, the issues of theses documents are those listed in the issue of the Department of Defense Index of Specifications and Standards (DODISS) and supplement thereto cited in the solicitation (see 6.2).

SPECIFICATIONS

ANSI/ASQCZ1.4

COMMERCIAL ITEM DESCRIPTION

A-A-50067 A-A-50186 A-A-50196 A-A-50198 A-A-50199 A-A-52106 A-A-52071 A-A-55187 FEDERAL	Cloth, Flannel, Wool Cloth, Buckram, Woven And No woven Thread, Silk Thread, Gimp, Cotton, Buttonhole Thread, Polyester Core; Cotton, or Polyester Covered Cloth, Twill Or Plain Weave, Polyester And Polyester Blend+++ Tape, Textile, Cotton, General Purpose (Unbleached, Bleached, or Dyed) Braid, Textile (Flat)
DDD-L-20 V-B-871	Label, for Clothing, Equipage, and Tentage (General Use) Button, Sewing Hole, and Button Staple (Plastic)
MILITARY	
MIL-B-3461 MIL-C-368	Buttons, Insignia, Metal, Uniform and Cap Cloth, Satin, Rayon and Cloth, Twill, Rayon
MIL-C-21115 MIL-C-44296 MIL-P-15064	Cloth, Tropical: Wool, Polyester/Wool Cloth, Fusible Pads, Shoulder and Sleeve-Head
STANDARDS	
MILITARY	
MIL-STD-129	Marking for Shipment and Storage
ASTM	
ASTM-D1974 ASTM-D6193	Box, Shipping, Fiberboard Stitches And Seams
ANSI	

Sampling Procedures and Tables for Inspection by Attributes

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2.1.2 <u>Standards Sources</u> Copies of specifications, standards, drawings and publications required by suppliers in connection with specific procurement specific procurement functions shall be obtained by contacting the following organizations:

2.1.2.1 FOR COMMERCIAL ITEM DESCRIPTION. FEDERAL OR MILITARY STANDARDS AND SPECIFICATIONS

Write to:

Document Automation and Production Service, Building 4/D 700 Robbins Avenue Philadelphia, PA 19111-5094.

Or Email: Welcome to the ASSIST

2.2 <u>Non-government publications</u>. The following documents form a part of this specification to the extent specified herein. Unless otherwise indicated, the issues of the documents, which are DOD adopted, are those listed in the issue of the DODISS cited in the solicitation. Unless otherwise specified, the issues of documents not listed in the DODISS are the issues of documents cited in the solicitation (see 6.2).

2.2.1 AMERICAN SOCIETY FOR TESTING AND MATERIAL

Write or call:

ASTM 100 Barr Harbor Dr, West Conshohocken, PA 19428-2959, Phone (610) 832-9585

Or Email: ASTM Standards Search

2.2.2 THE COLOR ASSOCIATION OF THE UNITED STATES

Write to:

Color Association of the United States, Inc. 343 Lexington Avenue
New York, NY 10016-0927

2.2.3 For American National Standard Institute such as the following

Write or call:

ASTM 1819 L Street NW 6th floor Washington, DC, 20036

Phone: 212-642-4900 (customer Service)

Or Email: ANSI Online

2.3. Order of precedence. In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3. REQUIREMENTS

3.1 <u>Guide sample</u>. Guide samples, when furnished, are solely for guidance and information to the contractor (see 6.3). Variation from this specification may appear in the sample, in which case this specification shall govern.

3.2 Sample Approval

3.2.1 <u>First article</u>. When required (see 6.2) and before each production is commenced, the contractor shall submit to the contracting officer, for approval, one finished coat -- men's service, size 38 regular -- conforming to the requirements of this specification. Contractors are notified that, where articles have been previously furnished and been accepted (within the last 5 years), the requirement for first article approval may be waived. Contractors must have the ability to develop and grade working patterns from first article or prototype garments submitted.

3.3 Materials

- 3. 3. 1 <u>Basic Fabric</u>. The basic fabric for the service coat shall be 10 -ounce cloth, tropical: wool, polyester/wool, USAFA blue shade 540, conforming to MIL-C-21115, as supplemented by USAFA Supplement 1, 28 March 1996. The material for the pocket flap linings shall conform to Type III o f MIL-C-21115. The government shall be responsible for sponging the fabric so that the maximum shrinkage after sponging shall be no more than 3% in either the warp or the filling direction.
- 3. 3. 2 <u>Twill Cloth.</u> The twill cloth for the inside hanging lower pockets, the inside hanging breast pocket, top of vent, the armholes, the shoulder and front interlining stays shall conform to Class 2 of A-A-52106, except that the non-fibrous materials, the seam efficiency and the colorfastness requirement shall not apply. The color shall be black and the minimum weight shall be 5 ounces per square yard.
- 3. 3. 3 <u>Buttons</u>. The buttons shall conform to Type I, Style 1, Class B, short shank (Wings & Star) of Specification MIL-B-3461. The size of the buttons shall be 36 line for the front and 25 line for the pockets. The buttons for the flaps of the inside lower hanging pockets and of the breast pocket shall be furnished with the split pin or the ring type toggles specified in MIL-B-3461. The stay buttons conform to Type II, Class D, Style 15, Size 18 line of V-B-871. The contractor may also use a machine lock stitch instead of a stay button. The color of the stay button shall approximately match the basic fabric.

3. 3. 4 Interlining.

- 3. 3. 4. 1 <u>Lining</u>. The lining for the body, sleeves, and the inside pocket pieces shall conform to Class 1 of MIL-C-368 and shall be USAF Color Shade No. 1086 (see 6.3).
- 3. 3. 4. 2 Interlining for front and sides. The interlining for the front and side shall be Type V, Class 1, Style B of MIL-C-44296.
- 3. 3. 4. 3 <u>Interlining for Sleeve Bottom.</u> The material for interlining the sleeve bottom shall conform to Type I of MIL-C-16735, except that the requirement for breaking strength shall not apply.
- 3. 3. 4. 4 <u>Padding for Front Interlining.</u> The material for padding the front interlining shall be flannel or felt. The flannel shall be fusible, unbleached, double-napped, cotton flannel cloth conforming to the requirements of Table I. The felt shall be natural-color, pressed felt and shall consist of wool and cotton; or wool, cotton and any other cellulose fibers conforming to the requirements of Table III. The polyamide dot coating shall increase the weight requirements from 5 to 6 ounces per square yard.
- 3. 3. 5 <u>Patch Pockets, Pocket Flaps and Shoulder Loops.</u> The interlining for the patch pockets, the pocket flaps and the shoulder loops shall be a lightweight fusible cloth that is suitable for the purpose intended, matching the basic fabric, and of good commercial quality.

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- 3. 3. 6 <u>Undercollar</u>. The material for the undercollar shall conform to A-A-50067, except that the colorfastness requirements to perspiration and crocking shall not apply. The color shall be USAF Color Shade No. 1549.
- 3. 3. 6. 1 <u>Undercollar Interlining.</u> The material for the undercollar interlining shall be in conformance with A-A-50186
- 3. 3. 7 <u>Identification of Service Coat.</u> Each coat shall have a combination contractor, identification, and care label and a removable paper size ticket with Code 39 bar code.
- 3. 3. 7. 1 <u>Combination Contractor, Identification, And Care Label</u>. The combination label shall be cloth, cotton, permanent-coated, conforming to Type VI, classes 1, 2, 10, and 14 of Specification DDD-L-20. The label shall show the following information:

Item Description		*	
Contract Number	*	Contract Date	*
Size		**	
Cadet Name			
SSN		Squadron	
Supplier's Name		*	
Fabric Content		*	
Care Instruction		*	

- * Applicable data to be inserted by the contractor when labels are printed.
- ** Applicable data to be stamped in by contractor using permanent-type black ink after labels are printed.
- 3. 3. 7. 2 Removable Size/Bar Code Ticket. The removable paper size ticket shall be approximately 2" X 3" and be of regular commercial paper construction. The letters and numbers for the size ticket shall be 1/4" high. Size 38 regular shall be expressed as 38R, etc. The code 39 bar code shall be 1/2" in height and shall reflect the stock number of the garment. For all coats, the label shall be tacked to the outside, lower part of the left sleeve.
- 3. 3. 8 Shoulder pads. The shoulder pads shall conform to Type I, Class 1 of MIL-P-15064. The curved edge, back half, shall be over edge stitched through all plies to prevent raveling, or needle punch shoulder pads can be used.
- 3. 3. 9 <u>Sleeve-Head Pads.</u> The sleeve-head pads shall conform to Type IV of MIL-P-15064. The front part of the sleeve-head pads for the coat shall be covered with bias-cut canvas that is 4 inches long by 3 inches wide and conforms to Type II of MIL-C-297.
- 3. 3. 10 Stay Tape. The tapes for staying the armhole and bridle shall be cotton, conforming to Type I, class 1 or 3 of A-A52071, except that the nonfibrous material content shall not apply. The color shall be natural, bleached or black. The tape for staying the bridle shall be ½ inch wide. The tape for staying the armhole shall be ¼ inch wide. The tape for back neckline shall be cross-cut, made from natural or dyed black polyester blend cloth conforming to class 1 of A-A-52106 The raw edges of the tape shall be treated with a synthetic resin to prevent raveling. The tape for the neckline shall be ½ inch wide.
- 3. 3. 10. 1 <u>Fusible Tape.</u> As an option, double-faced fusible tape may be used for the left vent and for anchoring the hanging pockets.

- 3. 3. 11 <u>Hanger</u>. The material for the hanger shall be cotton or rayon, tubular, flat braid. The braid shall be 1/8 inch to 3/16 inch wide and shall have a breaking strength of not less than 50 pounds in the warp direction. The braid shall be black and shall have good colorfastness to crocking and wet dry cleaning.
- 3. 3. 12 Cross Tape. The twill cloth for the cross tape for the back of the neck gorge of the fronts and for the fronts of the coats shall conform to Class 1 of MIL-C-43718, except that the requirements for non-fibrous material, and the cloth shall be cut across the width in strips of 5/8 inch (\pm 1/16") wide. The ends of the strips shall be abutted or overlapped and stitched with diagonal stitching. The diagonal stitching shall be a minimum of 8 stitches per inch with a bight (throw of 1/8 to 3/16 inch). The edges of the tape shall be treated with a synthetic resin to prevent raveling.
- 3. 3. 13 <u>Sleeve Braid.</u> The braid for each sleeve shall be braid, mohair, flat, one inch wide. The color shall be Cable Color No. 70090. The braid shall conform to Type I, Class 1, of MIL-B-593. The braid shall conform to Type I, Class 1, of A-A-55187.
- 3. 3. 14 <u>Thread.</u> All threads shall have good colorfastness to wet/dry cleaning and perspiration. The cotton or polyester-covered, polyester core thread shall conform to A-A-50199. The colored thread shall be DoD thread Shade Navy Blue AT, Cable No. 66060 and shall have good colorfastness to wet-dry cleaning, perspiration and light. The thread for topstitching shall be black. The cotton thread for seaming the coats shall conform to Table II A-A-50196. The silk thread for hand felling shall conform to Type III, Class 3, Ticket A or C, two-ply of A-A-50196. The silk thread for machine felling, shall conform to Type I, three ply of A-A-50196. The silk thread for machine edge stitching shall be black and conform to Type 1, No. A, 3-ply of, A-A-50196.
- 3. 3. 14. 1 <u>Silk Thread.</u> The thread for all topstitching, buttonholes and bartacks shall conform to Type I, Ticket No. A, B, and C, 3–ply of VT-301. (Except that the requirement for extractable material shall not apply).
- 3. 3. 14. 2 Cotton Thread. The thread for seaming and stitching the coat shall conform to A-A-50199.
- 3. 3. 14. 3 Gimp. The gimp for reinforcing the buttonholes shall be cotton size No. 8 conforming to type I or II of A-A-50198.
- 3. 4 <u>Design.</u> The coat shall be single-breasted, four-buttoned with notched lapels. The back shall be two pieces with center vent. The front shall have two pleated breast pockets with flaps. The lower pockets shall consist of flaps only, without pockets. Each flap shall have a cut first buttonhole, centered on the flap with the eyelet cut to accommodate a button held in place with a toggle. The inside coat shall be one-half lined with the exposed bound with piping and shall have one inside hanging pocket on the right front.
- 3. 5 Patterns. One properly sized and identified standard/master pattern size 38R shall be furnished upon request to the contractor by 34TRW/SDCU, Cadet Uniform Flight, for grading and development of necessary working patterns. The working patterns shall be identical to the USAFA pattern, and shall not be altered in any way. The patterns provide the following allowances: ½" for lapel and front edge seams; ¾" outlets on side seams and center back seam; ½" side body seam; ½" outlet on front of under sleeve, and lining; 1" turn up for bottom hem; and a 3/8" seam allowance for all other seams unless otherwise specified herein. The 34TRW/SDCU furnished pattern shall be returned to the Cadet Uniform Flight, 34TRW/SDCU, USAF Academy CO 80840-8210 prior to the last shipments being received by the USAF Academy.
- 3. 5. 1 <u>Parts.</u> The component parts of the coat shall be cut from materials as specified in accordance with the number of parts specified in Table VI.

TABLE II. PATTERN PARTS

Material	Pattern Part	Number of Parts
		to be Cut
Basic Fabric (Tropical Wool)	Front	2
· - ·	Back	2
	Side Body	2
	Front Facing	2
	Topcollar	1
	Topsleeve	2
	Underesleeve	2
	Shoulder Loop	4
	Breast Pocket	2
	Breast Pocket Flaps	2
Rayon Material	Lower Pocket Flap	2
	Front Lining	2 2
	Back Yoke	1
	Topsleeve Lining	2
	Undersleeve Lining	2
	Inside Breast Pocket Facing	1
	Back Vent Lining	1
	Armhole Shield	4
Cotton Flannel Cloth Or Felt	Front Chest Padding	2
Cotton and Spun Hair Interlining Cloth	Front Interlining	2
	Front Chest Piece	2 2 2
	Shoulder Wedge	2
Cotton and Horsehair Cloth or Cotton and Nylon Cloth	Front Interlining Shoulder Piece	2
Wool Flannel Cloth	Undercollar	1

TABLE II. PATTERN PARTS (Cont.)

Material	Pattern Part	Number of Parts
		to be Cut
Buckram Cotton Cloth	Undercollar Interlining	1
Twill Cloth	Inside Breast Pocket	1
	Breast Pocket Lining	2
	Inside Breast Pocket Stay	1
	Front Button Reinforcement	2
	Front Interlining Stay	2
	Breast Pocket Stay	2
Cotton Wigan Cloth	Sleeve Bottom Interlining Lapel Shaper	2
	Finished Lapel and Collar Shaper	
	Undercollar Shaper	
	Breast Pocket Shaper	
	Finished Breast Pocket Flap Shape	er

3. 6 Construction.

- 3. 6. 1 Stitches, And Seams. Stitch, and seam types specified in Table II shall conform to ASTM-D6193. Wherever 2 or more seam or stitch types are specified for the same operation, any one of them may be used. The ends of all seams and stitching produced with Stitch Type 301, if not caught in other seams or stitching, shall be back stitched not less than 1/4" Thread breaks (all stitch types) shall be secured by stitching back of break 1/2" to 1". The stitches per inch specified herein shall be interpreted to be the minimum and the maximum permitted.
- 3. 6. 1. 1 <u>Fusing.</u> Fusing operations shall be in accordance with the procedures recommended by the producers of the fusible materials.
- 3. 6. 1. 2 <u>Top and Edge Stitching.</u> Black silk thread shall be used for flap stitching, pocket setting and edge stitching. Shade of thread used in construction and assembling of component parts shall be used either black or dark blue. However, one kind of thread shall be used consistently throughout the coat during stitching operation.
- 3. 6. 1. 3 Bartacks. Bartacks shall measure 3/16" long, and be free from thread breaks and loose stitching.
- 3. 6. 1. 4 <u>Marking.</u> The component parts of the coat shall be marked to insure a uniform shade and size throughout the garment. Any method of marking may be used except:
 - a. Corrosive metal fastening devices. No metal device or sew-on type markings shall be used on rayon lining.
- b. Adhesive type tickets, which discolor the material or leave traces of paper or adhesive on the material after removal of the tickets.

NOTE: The use of ink pad numbering or machine rubber stamp or pencil is allowed, provided the numbering does not show on the outside of the garment, and wherever possible, is covered by the seam allowance.

3. 6. 5 <u>Use of Automated Apparel Equipment.</u> Automated apparel equipment may be used to perform any of the sewing operations, providing that the seam and stitch type are as specified and the finished component conforms to the required configuration.

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- 3. 7 <u>Wool Contents.</u> Each coat shall be labeled in accordance with the Wool products Labeling Act of 1939. The wool contents may be included in the combination contractor and identification label.
- 3. 8 Pressing. Pressing shall be performed by use of a heated pressing iron or machine as commercially used for dress coats.
- 3. 9 Workmanship. The coats shall be clean, finished correctly to include pressing by hand or machine, and free from any defects that might affect appearance or serviceability.
- 3. 10 <u>Finished Measurements.</u> The finished measurements of the coats shall conform to Table IV for Class 1, and to the made to measure ticket for Class 2.

TABLE III - MANUFACTURING OPERATIONS REQUIREMENTS				
OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREA D
1. CUT BASIC FABRIC	11112	SIIICIIIIE	II (CII	
a. The basic material shall be spread face to face. The spread of cloth shall be in a suitable number of plies for the applicable fabric.				
b. The material shall be carefully laid up in uniform widths and lengths. Care shall be taken in spreading the material so that the plies are not stretched or full and so that one side of the lay is even. Each component part in the top ply of the main lay shall be marked with the size of the coat.				
c. The coat shall be cut in strict accordance with the patterns, which shall show size, directional lines for cutting, markings, and notches for placement of pockets and flaps, shape, and proper assembling of all parts. All component parts to be cut from the basic material shall be cut from the same bolt of fabric.				
d. The front waist dart shall be cut in accordance with the marks on the patterns. The shoulder loops, the pocket flaps, and the top collar shall be cut across the width of the material. The flap lining shall be cut across the width of the material.				
e. The left front and front facing shall be trimmed in the front shaping operation. The use of drill holes for pocket darts and flap locations is prohibited.				
f. Replace at the time of cutting, any parts containing holes or weakening defects such as smashes, multiple floats, and slubs likely to develop into a hole.				
2. CUT THE LINING				
a. The material for the body lining, sleeve lining, armhole shields, right vent, yoke, and inside breast pocket facings shall be cut in the direction of the warp. The sleeve linings and the underside of the shields may be cut out of ends. When the sleeve linings are cut from ends, the parts shall match and the sleeves shall match each other.				

TABLE III OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
2. CUT THE LINING (cont.)				
b. Each component part in the top ply of the main lay shall be marked with the size of the coat.				
3. CUT TRIMMINGS				
a. Cut fusible interlinings in the same direction as the parts to fused.				
b. The cloth for armhole, shoulder and interlining stays shall be cut on the bias. The cloth for inside breast pocket, pocket stays and vent stays shall be cut in the direction of the warp.				
c. The felt fabric composite undercollar cloth shall be die-cut as indicated by the lines on the pattern.				
d. The wigan interlining for sleeve bottom shall be cut on the bias.				
e. The bindings for the bottom of the coat, side seams, center back seams, and the back edge of the left vent shall be bias cut and shall be 3/4 or 7/8 inch in width. The binding for the top edge of the outside breast patch pocket shall be 7/8 to 1 inch wide.				
4. REPLACEMENT OF DAMAGED PARTS.				
Care shall be exercised during the spreading, cutting and manufacturing operations to assure that material defects and damages (which may be a hole, scissors or knife cut, tear, holes, mends, burns, pull, snag, loop, etc) are excluded and replaced with non-defective and properly matched material.				
5. SHADE MARKING				
a. All component parts of the basic material and linings shall be marked to insure a uniform shade and size throughout the coat. Sleeve linings, whether cut from ends or in the main lay, shall be shade marked.				
b. The numbering shall, at all times, start from the same position for all parts, for example: If the ply, Number 1 is used for the top ply and the next ply below facing the top ply, shall be Number 1 for all parts.				

TABLE III OPERATION	STITCH	SEAM STITCH	STITCH	THREAD
c. The use of sew on tickets and metal fastening devices for	TYPE	TYPE	PER INCH	
shade marking is permitted on the basic fabric, but they shall not				
be used on the rayon linings.				
6. FUSING				
a. Fuse the side front armhole interlining with the armhole edge set back 1/8 inch and 3/8 inch from the edge of the side body to front joining seam. Fuse the back vent top and bottom.				
b. Fuse the small parts fusible interlining piece to the top and under sleeve, with the bottom edge of the fusible interlining 1/8-inch from the bottom edge of the sleeves, and center.				
c. Fuse the small parts fusible to the top collar. Position the top collar interlining, and center it on the top collar with 3/16 inch from all edges, as indicated on the pattern.				
d. Fuse the small parts fusible to the flaps and top welt aligned with the corresponding notches on the basic material.				
e. Fuse the small parts fusible to the left and right facings with the top of the fusible interlining 1/8-inch from the top of the shell.				
7. MAKE INTERLINING FROM FRONTS.				
a. Spread the shoulder dart, and zigzag the wedge piece to the inside of the interlining at the shoulder dart with the edges overlapping.				
b. The abutted or overlapped edges, waist darts, armhole darts, and lower waist darts at the back edges of the interlining, respectively shall be zigzag stitched together through the twill cloth stay pieces. The abutted or overlapped edges may be stitched together prior to the stitching through the twill cloth stay pieces.				
c. Spread the shoulder dart on the chest piece of the interlining, and zigzag stitch the wedge piece to the shoulder dart, with the edges overlapping.	304		4-6	70/20

TABLE III OPERATION	STITCH	SEAM STITCH	STITCH	THREAD
	TYPE	TYPE	PER INCH	
d. The abutted or overlapped edges of the armhole dart on the chest piece shall be zigzag stitched together.			4-6	70/2
e. Position chest piece of canvas in front. With monoflex catch the horsehair or cloth piece in between.			4-6	70/2
f. Zigzag stitch on the front and bottom edges to the front interlining. Place an additional row of zigzag stitching vertically through the center of the chest piece.			4-9	70/2
g. Quilt the flannel or felt padding to the interlining, with rows of stitching 3/8 or 3/4 inch apart, with the flannel padding extending beyond the shoulder, the armhole, and the side of the interlining. The shoulder portion of the interlining shall be left open to accommodate the shoulder pad.			4-6	70/2
h. Zigzag stitch the back edge of the strip of the bias-cut twill cloth for reinforcing the buttonholes. The strip shall be 3 inches (plus or minus 1/4 inch) wide. The strip of twill cloth shall be positioned with the top edges even with the step and the front edge 1/4 inch from and parallel to, the front edge of the right front interlining. On the left front position, the front edge of the twill cloth strip even with the lapel edge at the step and aligned with the notch on the bottom of the interlining.				
I. The front interlining shall be shirred 3/8 to 1/2 inch approximately 3/4 inch back of the waist dart, and 1 inch from the front edge. The shirring shall measure approximately 3 1/2 inches in length above and below the waistline (twill cloth on the front shall not be caught in the shirring).	101 401	Osa-1	12-14	A 70/2
8. MAKE SHOULDER BOARD LOOPS				
a. Make shoulder board loops. A strip of polyester/wool shall be folded to the center with the edges overlapped and double stitched 3/16 to 1/4 inch gage with a covering stitch on the underside. Loops shall finish 3/8 inch wide.	406	EFH-1		A A

TABLE III OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
b. Cut four loops 1-7/8 inch long for each coat.				
c. Front end of loops shall be turned under prior to stitching onto coat. Back end of loops shall be caught in shoulder seam stitching.				
d. First loops on each shoulder shall finish 1-3/8 inch long and be located 3/4 to 1 inch up from armhole seam. Opening of first loops shall be 1-1/4 inch.				
e. Second loops on each shoulder shall finish 1-1/8 inch long in line with first loop and be 3-3/8 inch up from first loop, but not more than 4-1/8", see Figure 3. Opening of second loops shall be 1 inch.				
f. NOTE: The 3 - 3/8-inch measurement shall be from the outside of the other loop. Measurement for placement of shoulder loops shall be taken along the shoulder seam.				
9. MAKE BREAST POCKET				
The finished flaps shall finish with the corners pointed and conforming to the shape of the master pattern. Seam the lining to the flaps, trim away excess material, turn and single stitch edges of flap with 3/16 inch gage.	301	Sse-2	12-14	A silk or 00
10. MAKE TWO LOWER POCKETS				
a. Seam the lining to the flaps, trim the corners, turn and single stitch 3/16 inch from the edge. The lining may be joined to the flap with cotton thread. The edge stitching shall be performed with silk thread.	301	Sse-2	12-14	A silk or 00
b. When the lower flaps are cut from one piece of fabric, fold the flap in half, sew the ends with 1/4 inch seam, trim away excess material at corners, turn and stitch edges with 3/16 inch gage.				
11. PRESS FLAPS a. After the buttonholes have been made, the flaps shall be pressed flat and smooth.				
b. The flaps shall be marked with appropriate marker before setting on coat, to insure proper dimension of the flap.				

TABLE III OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
12. MAKE BUTTONHOLES IN FLAPS	TITE	TILE	TEKINCII	
 a. Make a cut first buttonhole 7/8 inch long through the center of each lower flap. The eyelet shall be 5/8 + 1/8 inch up from the bottom edge of the flap. b. Make a cut first buttonhole 7/8 inch long through the center of each breast pocket flap. The eyelet shall be 5/8 + 1/8 inch up from the point of the flap. NOTE: The purling shall finish on the right side of the flaps. 	Buttonhole Machine		38-40 buttonhole not including bartack	
c. The ends of the buttonhole thread and gimp shall be securely bartacked. Clip threads close to bartack.	Bartack		21 per bartack	A A
d. The buttonholes shall not be cut open except the eyelet which shall be cut out. Bartacking shall be a separate operation from the buttonhole making.				
e. The bartack may be done by hand, but shall not be more than 3/16 inch long.	Hand or machine		10-12 per bartack	A skein
13. MAKE TWO BREAST PATCH POCKETS CREASING MACHINE CONSTRUCTION				
a. Form a 1-1/2 inch wide vertical box pleat to the outside in the center of the pocket by creasing machine. Stitch the pleat closed, across the top and the bottom, with the inside side edges abutted.	301	Ssa-1	4-8	A A
b. Blind stitch the abutted edges of the pleat	301	Ssm-1	4-8	A A
c. Place the twill cloth pieces to back of the patch pocket (underside). Seam around, at the side and the bottom, 1/8 to 3/16 inch from raw edge. The sides and the bottom edges shall be creased to conform to proper shape as shown by the pocket shapers.	301	Ssa-1	12-14	A A
d. Form a 1-1/2 inch wide, vertical box pleat to the outside in the center of the pocket and stitch.	301	Osf-1	12-14	A A
e. Stitch across the top and the bottom of the pleat.	301	Ssa-1	12-14	A A
f. Baste the center of the pleat by machine, with a long stitch.	101 or 301 or hand		12-14	A A

TABLE III OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
g. Press the pleat (in the center of the pocket) flat and smooth with a heated pressing iron or machine.				
h. Seam the twill cloth lining to the pocket around the side and the bottom edges.		Ssa-1		A A
i. Trim the bottom corners of the pockets.				
j. Turn the pocket and baste the edges with the twill cloth lining slightly back from the pocket edges. In lieu of basting, a cardboard template the shape and size of the patch may be inserted between the twill cloth and basic material and pressed.				
k. Put on a shaper and trim the top edges if necessary. Stitch across the top of the pocket.		Ssa-1		A A
1. Press the pockets smooth with a heated pressing iron or machine.				
m. The top raw edge of the patch pocket shall be trimmed and the edge shall be serged. This may be done in one operation.				
14. MAKE COLLAR				
a. Join the undercollar pieces.	301	Ssa-1	12-14	A A
b. Join the undercollar interlining.	301	Ssa-1	12-14	A A
c. Open the undercollar seam and stitch one side of the seam allowance to the interlining, or press the undercollar seam open with a heated pressing iron or machine. If the undercollar and the interlining are cut in one piece, a, b and c will not be required.				
d. Quilt the interlining to the undercollar with seven to eight rows of blind stitching.				
e. Press, and mark undercollar with collar shaper, cut excess material - or the undercollar may be shaped with a die-shaper to conform to undercollar shaper.				
f. Mark undercollar stand. The stand shall be 1-1/4 inches wide at the center of the collar, measured from the lower edge of the undercollar.				

STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
301	Ssa-1	12-14	A A
301 or 304	Lsa-1	4 to 6	A A
101 or hand			
101 or			
hand			
nand or machine			
301	Ssa-1	12-14	A A
	TYPE 301 301 or 304 101 or hand 101 or hand hand or machine	TYPE TYPE 301 Ssa-1 301 or 304 Lsa-1 101 or hand hand or machine 301 Ssa-1	TYPE TYPE PER INCH 301 Ssa-1 12-14 301 or 304 Lsa-1 4 to 6 101 or hand hand or machine 301 Ssa-1 12-14

TABLE III OPERATION	STITCH	SEAM STITCH	STITCH	THREAD
c. Stitch the interlining to the underarm seam and the sides of	TYPE 301	TYPE Ssa-1	PER INCH 6 to 14	A A
the back arm seam. The bottom edge of the cuff interlining	301	35a-1	0 10 14	AA
shall be 1/2 to 3/4 inch below the turn up notches.				
d. Mark bottom line for sewing on the sleeve braid. The lower edge of braid shall be 3-1/16 inch above the turn up				
mark.				
e. Sew on braid to sleeve on top and lower edges 1/16-inch gage. Lower edge stitching of braid shall catch the wigan piece. Wigan piece shall extend 3/4 inch below the turn up notch.	301	Ssa-1	12-14	A A
f. Press the braid and the turn up of sleeves.				
g. Mark and baste the turn up of the bottom of the sleeve.	101 or hand			
h. Press the bottom of the sleeves, and pull out the basting.				
i. Join the back arm seam of the sleeves with a 3/8-inch seam allowance catching wigan and braid in the seam. The braid shall join evenly at the back arm seam in the finished sleeve.	301	Ssa-1	12-14	A A
j. Press back arm seam open and flat with a heated pressing iron, holding the seam short.				
k. Blind stitch the turn up of the sleeve to the interlining.				
l. Join the back arm seam and one forearm seam of the sleeve linings, respectively.	103 or 301 or hand	Efc-1	4-6 1-2	Nylon/50
m. The sleeve linings shall extend not less than 3/4 inch or more than 1 inch above the top of the sleeve. Tack the	301	SSa-1	12-14	A A
forearm seam and the back arm seam of the sleeve lining to the forearm seam and the back arm seam of the sleeve, respectively, distributing fullness of lining during the tacking operation. Extend tacking from not more than 5 inches below the top to not more than 5 inches above the creased bottom edge. When tacking is done by hand, both ends of the	301 101 or hand		4-6 ½ to 1	4 6 ½ to 1
stitching shall be securely backstitched with not less than three stitches. NOTE: When 101 is used, 2 tacks on front seam; 3 tacks on the back seam.				

TABLE III OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
n. Baste the turn up of the sleeve lining. It shall be not less than 2 inches. The sleeve lining may be felled to the bottom of the sleeve without basting.	Hand or Machine 101			
o. Turn the sleeves and assemble in pairs.				
16. MAKE LININGS.				
a. Stitch the side body to the front of the linings.	301	SSa-1	12-14	A A
b. Fold and stitch the dart as indicated by the marks on the pattern.	301	OSf-1	12-14	A A
c. Stitch the forepart linings to the facings.	301	SSa-1	12-14	A A
Form and stitch the pleat at the front of the armhole as indicated by the patterns or the pleat may be formed when basting the lining.	hand or machine			
17. MAKE INSIDE BREAST POCKET				
Mark the position as indicated by the pattern for a 3/16 inch to 1/4 inch double piped pocket on the right side through the lining, the facing, and the twill cloth stay. The twill cloth stay shall extend and shall be caught in the armhole. The opening of the finished pocket shall be not less than 5 1/2 inches. The depth of the finished pocket shall be not less than 6 1/2 inches.				
a. The bottom raw edge of the rayon facing shall be turned in and seamed to the twill cloth pocket.	301	Lsd-1	12-14	A A
b. The top raw edge of the rayon facing shall be turned in and seamed in the twill cloth pocket. When either edge is selvage, it does not need to be turned in. Position the twill cloth pocket on the rayon lining and the wool polyester facing at the marks, with the twill cloth stay on the underside.	301	Lsd-1	12-14	AA
c. The silesia pocket shall be seamed to the lining and the facing throughout the twill cloth stay with two rows of stitching.	301	SSv-2	12-14	A A
d. The opening of the pocket shall be cut. The ends of the opening shall be tongue notched. The opening of the pocket shall not extend into the facing more than 1- 1/2 inch or into the armholes.				

TABLE III OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
e. Turn the pocket through the cut opening. Make the top and the bottom piping, and securely tack the corners. Turn the pocket into position and stitch around the sides and bottom of the twill cloth pocket. Stitch through the lining and the stay piece from the back end of the pocket opening to the armholes.				
f. The pocket opening may be accomplished with a double piped pocket machine, which stitches, cuts, and turns piped edges in one operation. When this machine is used, the piping piece may be trimmed to permit insertion into the machine.			12-16 12-16	A A
g. The joining seams of the piped edges shall be raise stitched. The bottom of the piped edges shall be raise stitched through the lining and the coat facing prior to closing the pocket. The top piped edge shall be raise stitched through all plies (not in piping) in closing the top of the pocket.				
18. MAKE ARMHOLE SHIELDS				
The armhole shield shall be a triangular, one piece, and rayon material sweat shield. The raw edges shall be sewn into the lining dart seam. Press the shield smooth and flat.	301	Ssa-1	12-14	A A
19. YOKE				
The yoke shall be made of rayon material.	301	Efb-1	12-14	A A
a. Hem the bottom edge of the yoke with the raw edges turned in to finish 1/2 inch. Fold the pleat in the center back of the yoke as indicated by the pattern notches and press.				
b. Press the seam joining the front body lining to the facing and the side body to one side towards the side seam. Press the pockets smooth and press open the bottom of the joining facing seam.				
20. MAKE BACKS	301	Dah 1	12 14	
a. Bend the edges of the side seams of the backs, both edges of the center back, and the edge of the left vent with a 3/4 inch to 7/8 inch, bias cut, rayon binding.		Bsb-1	12-14	AA
b. Join the center back seam with a 3/4-inch seam; continue stitching to 1/2 inch below the top of the vent. Continue stitching across the top of the vent.	301	SSa-1	12-14	AA

TABLE III OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
c. Notch the center seam allowance at the top of the vent. Press the center seam open and flat. Press the left vent edge.	301	Sse-2	12-14	A A
d. Join the rayon lining to the right vent, with the raw edges even, turn and stitch 1/8 inch from the edge and continue across the top of the vent lining.				
e. Tack the top folded edge of the lining vertically through the back seam outlet only.	Hand or machine		6-8	A nylon A
f. Tack the top of the vent through all plies of materials including the rayon lining. The outside tack shall be diagonal and shall be not less than 1 inch long.	301		12-14	A silk or 00
g. Baste the yoke to the back.	hand			
h. Sew the hanger braid to the center of the back at the collar seam. The finished hanger braid shall measure 2 inches long, + 1/2 inch.	machine 301 hopper		12.14	
i. Turn back the yoke and sew 1/4 inch tape on the backs of the armhole from the side seam to 3/4 inch from the shoulder seam, holding the tape taut to draw up the material, evenly	301 or 401	Ssa-1	12-14	A A
distributed 1/4 to 3/8 inch. Seam the cross cut tape across the neck of the back to within 1/2 inch of each shoulder part.	301 Or 401	Ssa-1	12-14	A A
j. The tape may be sewn on before the yoke is basted.				
k. Taping the armhole on the fronts and backs may be done in one operation.				
21. MAKE FRONTS		Ssa-1	12-14	A A
a. Join front darts, starting from nothing approximately 1 inch above the dart to 3/8 inch at center of cart and taper to nothing approximately 1 inch below the end of the dart.	301	SSW 1	12 11	
b. Join side body seam to front with 3/8-inch seam.	301	Ssa-1	12-14	A A
c. Sew 1/4-inch tape at forge, starting 1 inch in front of break line to 1/2 inch away from the shoulder seam.		Ssa-1	8-12	A A
	301			

STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
301	Lsd-1	12-14	A A Silk 00
301	Lsd-1	12-14	A A Silk 00
301	Lsq-2	12-14	A A Silk 00
301	Ssa-1	12-14	A A
301	LSq-2	12-14	A A silk 00
	301 301 301 301	301 Lsd-1 301 Lsd-1 301 Lsq-2 301 Ssa-1	TYPE TYPE PER INCH 301 Lsd-1 12-14 301 Lsq-2 12-14 301 Ssa-1 12-14

TABLE III OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
m. Press fronts on breast pressing machine.				
22. BASTING FRONTS TO INTERLINING				
The interlining shall extend well beyond the armhole.				
a. Baste the fronts to the interlining from below the shoulder, along the front dart seam to the bottom of the coat.	301 or hopper			
b. Tack the vertical front dart to the interlining. Securely tack the upper pocket stay to the interlining both front and back. When the upper pocket stay is tacked across the top, the middle row of interlining basting shall start at the top of the breast flap.	301 or hopper			
c. Baste across the shoulder, allowing room for setting the shoulder pads. Baste around the armholes and down the back edge of the interlining. Baste along the break line of the lapel and down the front edges.	301 or			
d. Baste the bridle tape 1/4 to 3/8 inch behind the break line of each lapel, holding the tape taut and holding in and properly distributing breast fullness. The bridle tape shall extend sufficiently above the gorge to permit catching the tape in the gorge seam tacking and to within 1 inch at the bottom. The tape shall be held taut enough to work in not less than 1/4 inch or not more than 5/8-inch fullness. The tape and interlining shall be stamp marked to assure proper fullness. The tape shall be marked 1/4 to 3/8 inch for sizes short and extra short. 1/2 inch for size regular, and 5/8 inch for sizes long and extra long.	nand			
e. The lapels of the coat shall be padded with six rows of blind stitching, with fullness on the interlining between the rows of stitching to roll lapels.	103 or 301	Ssa-6	4-6	Nylon
f. The bridle tape shall be blind stitched on the front and the back edges.	103 or 301	Ssm-6	4-6	Nylon
23. JOIN SIDE SEAMS				
a. Join the side seams, with a 3/4-inch seam, placing a 3/16-inch fullness evenly distributed on the back, starting 1 inch from the top edge of the step for a distance of 5 - 6 inches.	301	Ssa-1	12-14	A A

TABLE III OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
b. Press the side seam flat and open, holding the seam short and curved toward the front at the blade part of the seam. Press the tape at the armhole, holding the back short.	TILL	IIIL	1 LK IIVEII	
24. UNDER PRESS LAPELS AND FRONTS AND SHAPE LAPELS				
a. After the lapels are padded, the left ad right fronts of the coats shall e pressed individually on a breast pressing machine to the shape of the body. The front edge of the forepart shall be straight from the top of the lower flap. The front darts shall curve toward the front edge of the center.				
b. Position a lapel shaper from the point of the shoulder to the notch at the bottom of the stand and mark both notches. Mark and trim as shown on shaper.				
c. Trim the right front and bottom of coat matching lengths. Trim interlining at edges of the lapels, bottoms and front 1/4-inch.				
25. BASTE FACING				
Place facing on top of fronts. Baste along the edges, and place required fullness at the corners of the lapels ad over the chest area. Hold the facing taut at the bottom edge of the front.	Hand or hopper			

TABLE III OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
26. TAPE AND STITCH EDGES	301	Ssa-1	12-14	A A
a. Seam the tape to the edge of the coat from the collar notch, across the top of the lapel, down the front and across the bottom to the back edge of the facing. The width of the seam allowance along the lapel and the front edges shall be 3/16 inch.				
b. Fell the back edge of the tape to the coat on the fronts and the lapels, or the tape may be felled by hand.	301 or hand	Ssm-1	3 to4	Nylon
c. Press the edges flat and smooth, and edge seam may be pressed open.				
27. BIND BOTTOM EDGE OF COAT				
Bind the bottom edge of the coat with 3/4 inch to 7/8 inch binding. The binding shall extend from the vent to under the lining of the front.	301	Bsb-1	12-14	A A
28. PRESS, TRIM AND TURN EDGES				
a. Press edges of front flat on pressing machines, and remove bastings. Press edges open.	101 or hand	EFc-1	4-6	Polyester /nylon
b. Trim excess material from corners of lapels and bottom of fronts. Turn fronts.				/Hylon
c. Baste edges of fronts with chain stitch basting machine approximately 1/4 inch in from edge. Work out the corners of the lapels. The edges of the lapels and the fronts shall be finished so that the edge seam will not be exposed when the coat is finished. Continue basting along the bottom turn up of the coat, making sure that the center vent will finish with the left vent slightly longer than the right vent. Fell the bottom turn up.	101 or hand			
29. BASTE FACING ALONG FRONTS (SECOND BASTING)	301 or			
a. Baste the facing 1-inch from the edge.	hopper			

TABLE III OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
b. Place a row of basting diagonally from the break to the point of the lapel, placing proper fullness in the facing to permit the lapel to roll.				
c. Baste the back edge of the facing, putting fullness over the chest.				
30. SEW ON SHOULDER PADS.				
Insert the shoulder pads between the interlining, the chest piece, and the felt or the flannel and securely baste to shoulder in proper position.				
31. FACING TO INTERLINING				
Tack the back edge of the right facing to the interlining with one row of blind stitching 2 1/2 inches from the shoulder seam to 2 1/2 inches above the inside pocket opening, and continue from the lower edge of the pocket to within 2 inches of the bottom of the coat. Tack the back edge of the left facing to the interlining not more than 2 1/2 inches below the shoulder seam to within 2 inches of the bottom of the coat.	301 or 103 hand	Ssm-1	3 to 4	Nylon
32. FIT AND BASTE LINING OF COAT				
a. Tack the back u-upper edge of the inside pocket to the interlining.	301 or hand	Hopper	4 to 6	
b. Baste pleat at armhole. The pleat shall be 1 inch deep and approximately 8 inches long and shall be parallel with the edge of the facing, approximately 1 1/2 inches away from the facing.	301 or hand	Hopper		
c. Baste across the shoulders, around the armhole, and down the side 1/2 inch off the side seam, and across the bottom.	301 or hand	Hopper		
d. Turn in the bottom and the back edge of the lining and baste to the coat. The basting shall allow room for felling of the side seams and the bottom	301 or hand	Hopper		
e. Trim the gorge and the lining of the armholes and the shoulders.				A A polyester
33. FELL LINING	301	EFc-1	4-6	
Fell the bottom and the sides of the lining with a blind stitch.				

33. FELL LINING (CONT)	TYPE	TYPE		
33. FELL LIMING (CONT)			INCH	
a. The seam of the sleeve lining shall correspond with the seam of the sleeve during the armhole felling operation.				
b. Fell the sleeve lining at the turn-up by hand, or the lining may be felled to the bottom of the sleeve by machine. Fell the lining of the shoulders.				
c Fell the lower back edge of the facings to the hem and the bottom corners of the lining at the joining of the lining to the facing. The bottom edge of the facing will not extend below the bottom edge of the coat.				
34. JOIN SHOULDER SEAMS Join the shoulder seams with a 3/8 inch seam, working in proper fullness on the backs. The fullness on the back shall be worked in manually without stretching the front at the shoulder.				
35. PRESS SHOULDER SEAM Open and press the shoulder seam, holding the shoulder short, with a heated hand iron or pressing machine over a suitable block.				
Dogition the choulder and bacta the unner part of each	Hand or machine			
37. SET ON COLLAR a. Mark the outlet at the neck with a shaper.				
b. Seam the topcollar to the front facings at the gorge to a point not less than 1 inch back of the lapel break line.	301			
Le Tack the gorge seam open catching the bridle tape in the	301 or hand	Ssa-1	12-14 3 -4	A A A A
	hand		2	AA
Le Tack the outlet at the neck. Turn under and haste the lower. L	103 or hand			

TABLE III OPERATION	STITCH TYPE	SEAM STITCH TYPE	STITCH PER INCH	THREAD
f. Fell the undercollar to the coat and tack the corners.	Hand		8-10	C-nylon
g. Fell the lower edge of the topcollar from gorge seam to gorge seam by hand.	Hand		8-10	C-nylon
38. STITCH FRONT AND COLLAR EDGES				
Stitch the edges of the coat and the collar 3/16 inch from the edge. The stitching shall extend across the bottom width of the facings.	301	Sse-2 show finished	12-14	A A silk
39. PRESSING				
a. Between the firs pressing operation and completion of pressing, place the coat on a hanger. Press the edges of the lapel fronts, collar, and bottom of coat on an edge-pressing machine. Press the right and left fronts on right and left chest machines, respective.				
b. The front of the sleeve shall be rolled pressed. Press the balance of the front, the side sea, and the back of the coat (body machine). Press the collar on a collar machine, creasing on the break line and shaping to obtain the proper contour while pressing.				
c. Press the armholes and the shoulder (shoulder machine). Crease the armhole solid on the inside of the armhole. (armhole machine) Block the armholes; the topsleeve shall be shrunk in.				
d. Press the lapels. The creasing of the lapels shall extend a uniform distance from the gorge seam. The lapel shall be rolled pressed from				

TABLE III OPERATION	STITCH	SEAM STITCH	STITCH	THREAD
40. FINISH PRESS	TYPE	TYPE	PER INCH	
a. Press the coat lining smooth with a hand iron.				
b. Remove gloss, wrinkles, creases, spots and impressions on the fronts under the lapels, on the collars, on the right back under the left vent, on the shoulders and on the patch pockets under the flaps.				
c. Brush the coat and examine.				
d. Touch up any spots missed by the machine pressing.				
41. MARK FRONT FOR BUTTONS				
Mark the location of the four buttons on the right front of the coat, to correspond with the buttonholes on the left front. Sew buttons 1 - 5/8 to 1- 7/8 inches from the front edge.				
42. SEW ON BUTTONS				
a. Sew four 36-line buttons with wings and star upright each of the marks on the right front through a 4-hole plastic stay button on the underside.	Hand or machine			
b. Attach 25-line button through each pocket flap buttonhole with shank of buttons inserted through the eyelet and secured with a pin toggle.	Hand or machine			

4. OUALITY ASSURANCE PROVISIONS

- 4. 1 <u>Responsibility for Inspection.</u> Unless otherwise specified in the contract or purchase order, the supplier is responsible for the performance of all inspection requirements as specified herein. Except as otherwise specified in the contract or order, the supplier may use his own or any commercial laboratory acceptable to the government. The Cadet Uniform Flight (34TRW/SD/CU) reserves the right to perform any of the inspections set forth in the specification where such inspections are deemed necessary to assure that the finished product conform to prescribed requirements.
- 4. 1. 2 <u>Responsibility for Dimensional Requirements.</u> Unless otherwise specified in the contract or purchase order, the contractor is responsible for ensuring that all specified dimensions have been met. When the dimensions cannot be examined on the end item, inspection may be made at any point or at all points in the manufacturing process necessary to ensure compliance with all dimensional requirements.
- 4. 1. 3 <u>Certificate of Compliance.</u> Where certificates of compliance are submitted, the Government reserves the right to request certification of compliance and/or test such items to determine the validity of the certificate.
- 4. 2 Classification of Inspection. The inspection requirements specified herein are classified as follows:
 - 1. First Article Inspection
 - 2. Quality Conformance Inspection
- 4. 3. <u>First Article Inspection.</u> The first article shall be inspected as specified in this document for compliance with design, construction, workmanship, and dimensional requirements.
- 4. 4 <u>Quality Conformance Inspection.</u> Unless otherwise specified herein, inspection shall be in accordance with ANSI/ASQC Z1.4-1993.
- 4. 5 <u>Component and Material Inspection.</u> In accordance with 4.1, components and materials shall be tested in accordance with all the requirements of referenced specifications, drawings and standards unless otherwise excluded, amended, modified or qualified in this specification or applicable purchase document.
- 4. 6 Examination of End Item. The end item shall be examined for defects. Except for defects with an asterisk (*) in the classification column, all defects found during this examination shall be classified in accordance with Table V and Table VI. Defects with an asterisk in the classification column shall be classified as a major defect when affecting appearance or serviceability seriously, and as a minor defect A when affecting appearance or serviceability, but not seriously. The inspection levels shall be II of ANSI/ASQC Z1.4-1993 for major and minor A combined, and S-3 of ANSI/ASQC Z1.4-1993 for minor B. The acceptable quality level for major and minor A combined shall be 2.5 defects per 100 units for major and minor A and B combined).

4. 7 Finished Measurements:

a. Chest

b. Waist

c. Coat Length

d. Sleeve Inseam

Any measurement deviating from the nominal dimensions and tolerances specified in Table IV will be scored as a size-measurement defect.

Note: Measurements will be made as described in footnotes below Table IV.

Inspection levels and acceptable-quality levels (AQL's), expressed in defects per hundred units (dhu), shall be in accordance with ANSI/ASQC Z1.4-1993, as follows:

	\underline{AQL}	<u>Inspection Level</u>
Major	2.5	II
Major and Minor A	15.0	II
Major, Minor A, Minor	40.0	II
B (Combined)		
One Class	4.0	S-3

TABLE IV FINISHED MEASUREMENTS IN INCHES

Sizes	½ Breast (1)	½ Waist (2)	Back Width (3)
33	18	16	15 ½
34	18 ½	16 ½	15 3/4
35	19	17	16
36	19 ½	17 ½	16 1/4
37	20	18	16 ½
38	20 ½	18 ½	16 3/4
39	21	19	17
40	21 ½	19 ½	17 1/4
41	22	20	17 ½
42	22 ½	20 ½	17 3/4
43	23	21	18
44	23 ½	21 ½	18 1/4
45	24	22	18 ½
46	24 ½	22 ½	18 3/4
47	25	23	19
48	25 ½	23 ½	19 1/4
49	26	24	19 ½
50	26 ½	24 ½	19 3/4
51	27	25	20
52	27 ½	25 ½	20 1/4
53	28	26	20 ½
54	28 ½	26 ½	20 3/4
55	29	27	21
56	29 ½	27 ½	21 1/4
Tolerance	<u>+</u> ½"	<u>+</u> ½"	+ 1/4"

- (1) Breast measurement shall be taken with coat buttoned from folded edge to folded edge at base of armhole
- (2) Waist measurement shall be taken from folded edge to folded edge between the two bottom buttons on front closure
- (3) Back width measurement shall be taken across back 3 ½" below shoulder seam.
- (4) Sleeve inseam measurement shall be taken along inseam from pit of armhole to bottom edge of sleeve.
- (5) Back length measurement shall be taken along center back seam from lower edge of under collar to bottom edge of coat.

TABLE IV FINISHED MEASUREMENTS IN INCHES: BACK LENGTH (5)

Size	Extra	Short	Medium	Regular	Medium	Long	Extra	Extra Extra
	Short		Regular		Long		Long	Long
33	27-1/4	28-1/4	28-3/4	29-3/4	30-1/2	31-1/2	32-3/4	34-1/4
34	27-1/2	28-1/2	29	30	30-3/4	31-3/4	33	34-1/2
35	27-1/2	28-1/2	29	30	30-3/4	31-3/4	33	34-1/2
36	27-3/4	28-3/4	29-1/4	30-1/4	31	32	33-1/4	34-3/4
37	27-3/4	28-3/4	29-1/4	30-1/4	31	32	33-1/4	34-3/4
38	28	29	29-1/2	30-1/2	31-1/4	32-1/4	33-1/2	35
39	28	29	29-1/2	30-1/2	31-1/4	32-1/4	33-1/2	35
40	28-1/4	29-1/4	29-3/4	30-3/4	31-1/2	32-1/2	33-3/4	35-1/4
41	28-1/4	29-1/4	29-3/4	30-3/4	31-1/2	32-1/2	33-3/4	35-1/4
42	28-1/2	29-1/2	30	31	31-3/4	32-3/4	34	35-1/2
43	28-1/2	29-1/2	30	31	31-3/4	32-3/4	34	35-1/2
44	28-3/4	29-3/4	30-1/4	31-1/4	32	33	34-1/4	35-3/4
45	28-3/4	29-3/4	30-1/4	31-1/4	32	33	34-1/4	35-3/4
46	29	30	30-1/2	31-1/2	32-1/4	33-1/4	34-1/2	36
47	29	30	30-1/2	31-1/2	32-1/4	33-1/4	34-1/2	36
48	29-1/4	30-1/4	30-3/4	31-3/4	32-1/2	33-1/2	34-3/4	36-1/4
49	29-1/4	30-1/4	30-3/4	31-3/4	32-1/2	33-1/2	34-3/4	36-1/4
50	29-1/2	30-1/2	31	32	32-3/4	33-3/4	35	36-1/2
51	29-1/2	30-1/2	31	32	32-3/4	33-3/4	35	36-1/2
52	29-3/4	30-3/4	31-1/4	32-1/4	33	34	35-1/4	36-3/4
53	29-3/4	30-3/4	31-1/4	32-1/4	33	34	35-1/4	36-3/4
54	30	31	31-1/2	32-1/2	33-1/4	34-1/4	35-1/2	37
55	30	31	31-1/2	32-1/2	33-1/4	34-1/4	35-1/2	37
56	30-1/4	31-1/4	31-3/4	32-3/4	33-1/2	34-1/2	35-3/4	37-1/4
	Extra	Short	Medium	Regular	Medium	Long	Extra	Extra Extra
	Short		Regular		Long		Long	Long
Sleeve Inseam (4)	16 1/4	17 1/4	17 3/4	18 1/4	18 3/4	19 1/4	20 1/4	21 1/4
		Toleran	ce: Back leng	gth +/-1/2",SI	eeve Inseam	+/- 1/4"	1	1

4. 8 General Defects. General defects will be classified as follows:

TABLE V GENERAL DEFECTS			
	CLASSIFICATION		
	MAJOR		NOR _
1 MATERIAL DEFECTS AND WORKMANGHIR DAMAGES		A	В
1. MATERIAL DEFECTS AND WORKMANSHIP DAMAGES.			
A nonweakening condition that is inconspicuous shall not be classified as a defect. A material defect or workmanship damages shall be classified as follows only when the condition is one that definitely weakens the fabric or when it is conspicuously located so that it is clearly noticeable.			
a. Any hole	*		
b. Any weakening defect such as smash, multiple float, knot, or loose slub that might develop into a hole.	*		
c. Any shade bar or slub on outside of coat.	*		
(1) On outside	*		
(2) On inside (except sleeve linings and shields)		X	X
(3) Sleeve linings and shields d. Needle chew that might develop into a hole.	*		Λ
e. Scissors or knife cut, tear, mend, pull, snag, loop, or burn.	*		
2. SHADED PARTS.			
a. On outside (1) Any shaded part (except undercollar parts, and flap lining)	*		
(2) Undercollar parts badly shaded, when two piece collar is used. b. On inside		X	
(1) Any lining parts badly shaded, affecting appearance (except		X	
under part of shields, right vent lining, or sleeve linings)			
(2) Upper part of shield or right vent		37	X
(3) Sleeve lining parts badly shaded		X	
3. CLEANNESS.			
a. Any spot or stain clearly noticeable on the outside.	X		
b. Any spot or stain clearly noticeable on the inside.		X	
c. One or more bastings not removed.			
d. Thread ends not trimmed or basting not removed throughout coat or one or more shade tickets not removed			X
4. COMPONENTS AND ASSEMBLY.			
a. Any defective component or assembly defect (not classified herein).	*		
b. Any component or required operation omitted (unless otherwise classified herein).	*		

TABLE V GENERAL DEFECTS				
	CLASSIFICATION		ON	
	MAJOR		IOR	
		A	В	
<u>5. CUTTING.</u>				
a. Left front facing not dressed		X		
b. Undercollar cloth or collar interlining not cut on bias.	X			
c. Top collar and shoulder loops not cut with long dimension across width	X			
(filling) direction of cloth.		37		
d. Pocket flap lining not cut across width (filling) direction of cloth.		X X		
e. Rayon material for body lining, sleeve linings, or yoke	X	Λ		
f. Flap lining not cut from basic material. g. Rayon lining for right vent or inside pocket facing not cut in the length	Λ			
(warp) direction of cloth.		X		
h. Warp yarn line varying from front edge of left by more than ½".		X		
i. Warp yarn line varying from edge of left vent by more than ½".		X		
j. Warp yarn at inseam varying more than 1" but not more than 1 ½" when the		X		
top and the bottom of the sleeve at the inseam is used as a guide in inspection.				
k. Warp yarn at inseam varying more than 1 ½" when the top and the bottom	X			
of the sleeve at the inseam is used as a guide in inspection.				
6. PRESSING.				
a. Coat burned or scorched or pressing omitted.	*			
b. Coat armhole stretched.	*			
c. Sleeve not rolled-pressed on front part of sleeve.		X		
d. Armhole not creased on inside of armhole.		X		
e. Pressing omitted or poorly pressed, affecting appearance (unless otherwise		X		
classified).				
f. Armhole not blocked or poorly blocked.		X		
g. Gloss, wrinkles, creases, or basting impression not removed throughout				
major portion of coat.			X	
h. Pressing impressions not removed underneath the left vent, on the front			X	
underneath the collar or lapel, on the pocket underneath the flap, and on the shoulders (to be scored only when not removed in two or more places.				
i. Linings not pressed smooth.			X	
j. Armhole seam not pressed open across top from back notch to 4" forward of			11	
shoulder seam (Class 1 and 2 coats).		X		
k. Front or lapel edges bulky, i.e., not pressed solid.		X		

TABLE V GENERAL DEFECTS			
	CLASSIFICATION		ON
	MAJOR	MIN	IOR
		A	В
7. SEAMS AND STITCHINGS.			
 a. Any seam, twisted, puckered, or pleated affecting appearance. b. Part of coat caught in any unrelated operation or stitching exposed and visible on outside of coat, affecting appearance. c. Unsightly hand felling or blind stitching exposed and visible on outside of 	*	X	
coat, affecting appearance. d. Thread breaks (1) Not securely stitched back of break (2) Stitching secured but stitched back of break for a distance less than ½".		X X X	X
e. End of seam or stitching (stitch Type 301) when not caught in another seam or stitching not securely backstitched.f. Not specified shade of thread or two shades of thread used on outside of same coat.	*	X	
 g. Gauge of stitching (edge or raised stitching). (1) Irregular, i. e., unevenly gauged or various stitchings not uniform, affecting appearance. (2) Beyond range of width specified or varies more than 1/16" when 		X	
no range is specified.			X
(3) Any open seam on machine felling on inside. aa. Up to 1" inclusive bb. More than 1" h. Raw edges (raw edges not securely caught in stitching shall be classified as		X	X
such only when they occur at places where the edge is required to be turned under). (1) Any raw edge on outside			37
aa. Up to 1/8" inclusive. bb. More than 1/8" up to ½" inclusive. cc. More than ½"	X	X	X
 (2) Any raw edge (except seams when binding is not used). (3) Any raw edge, on seams when binding is not used, on inside. aa. More than ¹/₄" up to 1" inclusive. 		X	X
bb. More than 1".		X	A
8. BUTTONHOLES (CONSTRUCTION).			
a. One or more buttonholes omitted, added, or not specified type.b. Buttonholes not corresponding to size of buttons so that coat does not button properly.	X X		
c. Buttonhole stitching not securely caught in fabric, causing stitching to pull away from fabric	X		
d. Bartack missing or loose		X	

TABLE V GENERAL DEFECTS			
	CLASSI		
	MAJOR	MIN	IOR
		A	В
(1) One front buttonhole, or one or more flap buttonholes.	37	X	
(2) Two or more front buttonholes.	X		
e. Bartack misplaced not serving intended purpose on one or more			
buttonholes.			
(1) Front buttonholes		X	
(2) Flap buttonholes			X
f. One or more broken stitches	X		
(1) One front buttonhole.		X	
(2) Two or more front buttonholes.	X		
(3) One flap buttonhole.			X
(4) Two or more flap buttonholes.		X	
g. More than two stitches skipped.			37
(1) One buttonhole.		v	X
(2) Two or more buttonholes.		X	X
h. Ragged edges, affecting appearance.i. Not specified type, uncut buttonholes, except on lower pocket flap and		X	Λ
breast pocket flap.		Λ	
j. Gimp not pulled through to underside, on one or more buttonholes except on			
lower flap.			
k. Gimp omitted on one or more buttonholes.		X	
1. Cut of buttonhole			
(1) Beyond bartack on one buttonhole			X
(2) Beyond bartack on two buttonholes		X	
(3) Beyond bartack on three buttonholes.	X		
m. Stitches per buttonhole (not including bartack).			
(1) One or two stitches less than minimum specified.		X	
(2) Five or more stitches less than minimum specified	X		
O METAL INCICNIA DITTONO			
9. METAL INSIGNIA BUTTONS.			
a. One or more metal insignia buttons defective, bent, missing, loose,		X	
tarnished, or blistered.		Λ	
b. Buttons not specified type, size, or finish.		X	
c. Backstitching omitted or insecure on one or more hand sewn buttons.		X	
d. Insignia on buttons not in an upright position on front or flaps.		X	
e. Plastic stay button omitted.		X	
f. One or both toggles missing or defective.	X		
10. WOOL CONTENT LABEL(WHEN LEGEND IS NOT			
INCORPORATED IN COMBINATION CONTRACTOR AND			
IDENTICIATION LABEL)			
Label missing, incorrect, or illegible.			X

4. 9 <u>Detailed Defects.</u> The detailed defects of the coat shall be classified as follows:

TABLE VI DETAIL DEFECTS			
	CLASSIFICATION		
	MAJOR	MIN	IOR
		A	В
1. ALIGNMENT OF BUTTONS AND BUTTONHOLES			
a. Front button and buttonhole not aligned causing a noticeable bulge or twist on front when buttoned.		X	
b. Alignment of top front button with breast pocket button out of horizontal alignment by more than ½".	X		
2. LENGTH OF BUTTONED FRONTS			
 a. Left front shorter than right front at bottom corner (1) More than 1/8" but not more than 1/4". (2) More than 1/4". 	X	X	
b. Left front longer than right front at bottom corner. (1) More than ½" but not more than 3/8" (2) More than 3/8".	X	X	
c. Bottom corner of right front exposed beyond bottom edge of left front (1) More than 1/8" but not more than 1/4".	A	X X	
(2) More than ¹ / ₄ ".	X		
3. POCKET ALIGNMENT AND CONSTRUCTION			
a. Flaps (all flaps)			
(1) Lining tight or twisted, causing fullness or twist on flap.	*		
(2) Flap poorly shaped.	*		
(3) Stitching joining flap to front not caught through twill-cloth stay		X	
piece. (4) Corners of flap not securely back-stitched.		X	
(5) Raw edge exposed beneath top edge of flap.		X	

TABLE VI DETAIL DEFECTS			
	CLASSI	FICATI	ON
	MAJOR	MIN	NOR
		Α	В
b. Outside breast pocket flaps.			
(1) Flaps of outside breast pockets out of horizontal alignment.			
aa. More than 3/16 inch but not more than 3/8 inch.		X	
bb. More than 3/8 inch.	X		
(2) Flap not covering front corner of outside breast pocket opening.			
aa. One pocket.		X	
bb. Both pockets.	X		
(3) Flap not covering back corner of outside breast pocket opening.			
aa. One pocket.			X
bb. Both pockets.		X	
(4) Lower side edge of flap extending beyond outside breast pocket	t		
edge by more than 3/16 inch		X	
(5) Point at center of flap more than 1/4 inch from center of outside			
breast pocket pleat.	X		
(6) Point at center of outside breast flap more than 1/8 inch but not		W	
more than 1/4 inch from center of outside breast pocket pleat.	1	X	
(7) Side edge of outside breast pocket exposed beyond side of flap	бу		
1/8 inch to 3/16 inch.		v	
aa. Front edge of one or both pockets.		X	X
bb. Back edge of one or both pockets.	of		Λ
(8) Side edges of outside breast pocket exposed beyond side edges flap by more than 3/16 inch	01		
aa. Front edge of one or both pockets.	X		
bb. Back edge of one or both pockets.	Λ	X	
(9) Breast flap set on crookedly, affecting appearance.		X	
(10) Top edge of flap less than 5/8 inch or more than 1 inch above		71	
breast pocket opening.		X	
c. Flap buttonholes (position)		2.	
(1) Flap buttonhole positioned less than ½" but not less ¼" or more	,		
than 3/4" but not more than 7/8" from bottom edge.			X
(2) Flap buttonhole positioned less than 1/4 inch or more than 7/8			
inch from bottom edge.		X	
(3) Flap buttonhole finished with purling on the reverse side.	X		
(4) Flap buttonhole off-center of flap.			
aa. More than 1/8 inch but not more than 1/4 inch			X
bb. More than 1/4 inch		X	
d. Lower pocket flaps			
(1) Flaps on lower pockets out of horizontal alignment			
aa. More than 1/4 inch but not more than 1/2 inch			X
bb. More than 1/2 inch	X		

TABLE VI DETAIL DEFECTS			
	CLASSI	FICATI	ON
	MAJOR	MIN	IOR
		A	В
e. Breast pocket flap stitching (on sides)			
(1) Stitching omitted			
aa. One flap		X	
bb. Two flaps	X		
(2) Insecurely tacked			
aa. One flap			X
bb. Two flaps		X	
(3) Length of stitching less than 3/4" or more than 1".		X	
(4) Outside surface of flap puckered in stitching affecting appearance.		X	
(5) Stitching not coincident with edge stitching.		X	
(6) Not aligned causing a noticeable bulge or twist on flap when		7.7	
stitched affecting appearance.		X	
f. Lower flaps stitching (on sides)			
(1) Stitching omitted		v	
aa. one flap	v	X	
bb two flaps	X		
(2) Insecurely tacked			X
aa. one flap bb. two flaps		X	Λ
(3) Length of stitching less than 3/4 inch or more than 1 1/4 inch		Λ	
aa. less than 3/4 inch		X	
bb. more than 1 1/4 inch		Λ	X
(4) Outside surface of flap puckered in stitching affecting appearance.		X	Λ
(5) Stitching not coincident with edge stitching.		71	X
(6) Not aligned causing a noticeable bulge or twist on flap when			21
stitched affecting appearance.		X	
approxime with the second of t		- 1	
g. Alignment of breast pocket buttons and buttonholes. Outside breast pocket			
button not aligned with flap buttonhole, pulling or distorting pocket or causing			
flap to bulge or twist when buttoned, affecting appearance.		X	

TABLE VI DETAIL DEFECTS			
	CLASSI	FICATI	ON
	MAJOR	MIN	IOR
		A	В
h. Breast pockets (construction and alignment)			
(1) Serge stitching omitted.	X		
(2) Serge stitching top edge of breast pocket not securely caught to			
fabric causing stitching to pull away from fabric.		X	
(3) Twill-cloth lining exposed on breast pocket edge.	*		
(4) Twill-cloth stay omitted on the underside of one or both breast			
pockets.	X		
(5) Breast pocket corner not stitched through stay or corner not			
securely tacked.		X	
(6) Breast pocket poorly shaped.	*		
(7) Breast pocket varying in size or shape 1/4 inch or more from			
pattern shaper.	X		
(8) Breast pocket constructed with fold of pleats on the underside.		X	
(9) Pleat in breast pocket less than 1 3/8 inches or more than 1 ½		37	
inches wide.		X	37
(10) Pleat in breast pocket not stitched closed.			X
(11) Stitching across corner of opening and down sides of breast		X	
pocket aa. Omitted or insecure.		Λ	X
bb. Stitched for a distance of less than 5/8 inch.			Λ
(12) Bottoms of breast pockets out of horizontal alignment.		X	
aa. More than 3/16 inch but not more than 3/8 inch.	X	21	
bb. More than 3/8 inch.			
(13) Side of breast pocket not parallel with front edge of coat.		X	
aa. More than 1/4 inch but not more than 3/8 inch.	X		
bb. More than 3/8 inch.		X	
(14) Excessive fullness or tightness at breast pocket opening.			
(15) Pleat off-center of breast pocket (at lower edge of pocket flap)		X	
aa. More than 1/8 inch but not more than 1/4 inch.	X		
bb. More than 1/4 inch.		X	
(16) Breast pocket set on crookedly, affecting appearance.			
(17) Pleat off-center of breast pocket (at a point 1 inch above bottom of			
pocket).	***		X
aa. More than 1/4 inch but not more than 3/8 inch.	X		
bb. More than 3/8 inch.		v	
(18) Twill cloth tight or short, causing fullness or puckers on outside of pocket.		X	
of pocket.			
4. BODY LINING (FITTING)			
<u>2021 Shimio (FIFTHIO)</u>			
a. Body lining tight, short, or twisted, causing fullness or twists on outside of			
coat.	*		
b. Body lining too long, i.e., exposed beyond edge of coat, affecting			
appearance.		X	
5. FRONT INTERLINING (FITTING)			
b. Interlining too full, causing coat front to have a wavy appearance or not	*		
lying smoothly.	*		

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CLASSIFICATION MAJOR MINOR A B
6. FRONT AND BOTTOM EDGES a. Front edges stretched. b. Tape set on tight, causing puckering on front or bottom edges, affecting appearance. c. Front edge irregular, affecting appearance. d. Front edge not properly forced out, having a fold of more than 1/16 inch. e. Facing exposed on left front edge shaped, affecting appearance. f. Bottom corner of left front poorly shaped affecting appearance. g. Bottom edge stretched or uneven, affecting appearance. h. Front rolling outward below bottom button. 7. FRONT FACINGS Facing short, tight, or twisted, causing fullness or twists on front. 8. COLLAR a. Construction and setting. (1) Collar short, i.e., causing puckers on back on fronts or pulling lapel break line, causing fronts to roll out. (2) Collar long, i.e., setting away from neck or lapel not rolling to within 2 inches of top front button or buttonhole.
6. FRONT AND BOTTOM EDGES a. Front edges stretched. b. Tape set on tight, causing puckering on front or bottom edges, affecting appearance. c. Front edge irregular, affecting appearance. d. Front edge not properly forced out, having a fold of more than 1/16 inch. e. Facing exposed on left front edge shaped, affecting appearance. f. Bottom corner of left front poorly shaped affecting appearance. g. Bottom edge stretched or uneven, affecting appearance. h. Front rolling outward below bottom button. * T. FRONT FACINGS Facing short, tight, or twisted, causing fullness or twists on front. * 8. COLLAR a. Construction and setting. (1) Collar short, i.e., causing puckers on back on fronts or pulling lapel break line, causing fronts to roll out. (2) Collar long, i.e., setting away from neck or lapel not rolling to within 2 inches of top front button or buttonhole. * * * * * * * * * * * * *
a. Front edges stretched. b. Tape set on tight, causing puckering on front or bottom edges, affecting appearance. c. Front edge irregular, affecting appearance. d. Front edge not properly forced out, having a fold of more than 1/16 inch. e. Facing exposed on left front edge shaped, affecting appearance. f. Bottom corner of left front poorly shaped affecting appearance. g. Bottom edge stretched or uneven, affecting appearance. h. Front rolling outward below bottom button. 7. FRONT FACINGS Facing short, tight, or twisted, causing fullness or twists on front. 8. COLLAR a. Construction and setting. (1) Collar short, i.e., causing puckers on back on fronts or pulling lapel break line, causing fronts to roll out. (2) Collar long, i.e., setting away from neck or lapel not rolling to within 2 inches of top front button or buttonhole. *
b. Tape set on tight, causing puckering on front or bottom edges, affecting appearance. c. Front edge irregular, affecting appearance. d. Front edge not properly forced out, having a fold of more than 1/16 inch. e. Facing exposed on left front edge shaped, affecting appearance. f. Bottom corner of left front poorly shaped affecting appearance. g. Bottom edge stretched or uneven, affecting appearance. h. Front rolling outward below bottom button. * TRONT FACINGS Facing short, tight, or twisted, causing fullness or twists on front. * * * * * * * * * * * * *
c. Front edge irregular, affecting appearance. d. Front edge not properly forced out, having a fold of more than 1/16 inch. e. Facing exposed on left front edge shaped, affecting appearance. f. Bottom corner of left front poorly shaped affecting appearance. g. Bottom edge stretched or uneven, affecting appearance. h. Front rolling outward below bottom button. 7. FRONT FACINGS Facing short, tight, or twisted, causing fullness or twists on front. 8. COLLAR a. Construction and setting. (1) Collar short, i.e., causing puckers on back on fronts or pulling lapel break line, causing fronts to roll out. (2) Collar long, i.e., setting away from neck or lapel not rolling to within 2 inches of top front button or buttonhole. *
f. Bottom corner of left front poorly shaped affecting appearance. g. Bottom edge stretched or uneven, affecting appearance. h. Front rolling outward below bottom button. 7. FRONT FACINGS Facing short, tight, or twisted, causing fullness or twists on front. 8. COLLAR a. Construction and setting. (1) Collar short, i.e., causing puckers on back on fronts or pulling lapel break line, causing fronts to roll out. (2) Collar long, i.e., setting away from neck or lapel not rolling to within 2 inches of top front button or buttonhole.
7. FRONT FACINGS Facing short, tight, or twisted, causing fullness or twists on front. * 8. COLLAR a. Construction and setting. (1) Collar short, i.e., causing puckers on back on fronts or pulling lapel break line, causing fronts to roll out. (2) Collar long, i.e., setting away from neck or lapel not rolling to within 2 inches of top front button or buttonhole. *
8. COLLAR a. Construction and setting. (1) Collar short, i.e., causing puckers on back on fronts or pulling lapel break line, causing fronts to roll out. (2) Collar long, i.e., setting away from neck or lapel not rolling to within 2 inches of top front button or buttonhole.
a. Construction and setting. (1) Collar short, i.e., causing puckers on back on fronts or pulling lapel break line, causing fronts to roll out. (2) Collar long, i.e., setting away from neck or lapel not rolling to within 2 inches of top front button or buttonhole. *
(1) Collar short, i.e., causing puckers on back on fronts or pulling lapel break line, causing fronts to roll out. (2) Collar long, i.e., setting away from neck or lapel not rolling to within 2 inches of top front button or buttonhole.
lapel break line, causing fronts to roll out. (2) Collar long, i.e., setting away from neck or lapel not rolling to within 2 inches of top front button or buttonhole. *
(2) Collar long, i.e., setting away from neck or lapel not rolling to within 2 inches of top front button or buttonhole.
within 2 inches of top front button or buttonhole.
*
(3) Collar not properly set, causing a decided curve or bulge on crease
line at joining to gorge seam.
(4) Collar tight at joining to gorge seam across back, causing fullness
on lapels or fullness or pleats across outside of back
b. Collar edge
(1) Collar edge crooked, affecting appearance. X X
(2) Undercollar leaf exposed along collar edge for a distance of 1/2 inch or more, affecting appearance.
c. Gorge seam
(1) Gorge seam not spread open (any portion of seam on lapel side).
(2) Gorge seam not straight, affecting appearance.
(3) Tacking on gorge seam omitted.
(4) Tacking on gorge seam insecure.
d. Tacking on corner of undercollar to lapel omitted or insecure.
e. Topcollar
(1) Topcollar tight, i.e., causing edges to curl or bulge on undercollar.
(2) Topcollar twisted, i.e., having diagonal twist.
(3) Topcollar full, i.e., having puckers or fullness. X (4) Topcollar full, i.e. topcollar folds 1/8 inch or more from creased. *
(4) Topeonal ran, i.e., topeonal roles 1/8 men of more from creased
edge of undercollar. X (5) Topcollar edge irregular. X X

TABLE VI DETAIL DEFECT	`S		
	CLASS	IFICATI	ION
	MAJOR		NOR
		A	В
f. Undercollar			
(1) Interlining pleated, affecting smoothness of topcollar, affecting	eting	X	
appearance. (2) Interliging tight or twisted coasing pushers on undersoller.		X	
(2) Interlining tight or twisted, causing puckers on undercollar.(3) Undercollar tight at joining to fronts or back, causing puckers.		Λ	
pleats at neck.	*		
(4) Row of stitching along top and side edges of undercollar or	mitted.		X
(5) Undercollar stand less than 1 1/8 inches or more than 1 3/8			
wide at center.		X	
(6) Center seam of two-piece undercollar or center of one-piec	e		
undercollar not aligned with center seam of back by:			
aa. More than 1/4 inch but not more than 3/8 inch.			X
bb. More than 3/8 inch.		X	37
(7) Center back seam not pressed open.			X
(8) Tacking of neck outlet to undercollar across back omitted of insecure.	71		X
msecure.			Λ
9. LAPELS			
a Land facings			
a. Lapel facings(1) Lapel facing twisted, short, or tight, causing lapel to curl or	ut. X		
(2) Fullness or puckers in lapel facings.	ιι. Λ *		
b. Lapel edges			
(1) Edge of lapel irregular, affecting appearance.		X	
(2) Edge of lapel not properly forced out having a fold or more	e than		
1/16".			X
(3) Front part exposed on lapel by more than 1".		X	
(4) Tape set on tight, causing puckering at, any edge, affecting			
appearance.		X	
c. Bridle tape	~		
(1) Tape misplaced, not serving intended purpose, or extending beyond break line on the lapel side.	3	X	
(2) Tape excessively tight, causing puckers or pleats along breathing to the causing puckers or pleats along breathing the causing puckers or pleats along the causing p	ast line	X	
(3) Tape not held taut, causing lapel break line not to lay flat.		X	
d. Collar and lapel			
(1) Ends of collar or top edges of lapels on left side of coat not	egual		
in length.	- oquu:		
aa. 1/8" to ½".		X	
bb. More than ¹ / ₄ "	X		
(2) Pointed corner at collar end or at top edge of lapel poorly s			
(3) Lapels poorly shaped or not of uniform shape or size.	*		
(4) Collar ends or top edges of lapels equal in length buy varyi	ng		
from pattern shaper.		37	
aa. 1/8" or more but not more than ½".	v	X	
bb. more than ¹ / ₄ ".	X		
		<u> </u>	1

TABLE VI DETAIL DEFECTS			
	CLASSI	FICATI	ON
	MAJOR	MIN	IOR
		A	В
10. SHOULDERS			
a. Shoulder improperly joined or set, causing shoulder or back to twist.	*		
b. Shoulder seam curved towards back at armhole seam from normal position,			
i.e., from straight horizontal line.			
(1.) More than 3/16" but not more than 3/8".			X
(2.) More than 3/8".		X	
c. Shoulder pad not properly set on shoulder, causing shoulder to twist or	*		
pucker or causing shoulder lining or pad to bulge excessively. d. Shoulder pad not completely caught in armhole tacking.		X	
e. Shoulder pads misplaced, i.e., too far back or front, not serving intended		X	
purpose.		Λ	
purpose.			
11. SHOULDER BOARD LOOPS			
a. Construction and position:			
(1) Misplaced so that shoulder board shall not lay flat when buttoned,			
causing bulge or twist on shoulder.	*		
(2) Misplace so that shoulder board is too far back affecting	*		
appearance. (3) Ends of loops insecure	·		
aa. On 1 loop.			X
bb. On 2 loops.		X	71
cc. On more than 2 loops.	X		
(4) Omitted	X		
(5) Distance of loops from armhole seam			
aa. First loop less than 15/16" or more than 1 1/16".		X	
bb. Second loop less than 4 3/16" but not more than 4 5/16".		X	
cc. Second loop more than 4 5/16"	X		
(6) Spacing of first loop armhole-seam edge to the neck hole-seam	V		
edge of the second loop is more than 4 3/8".	X		
b. Openings (Gauge of Stitching)			
(1) first loop		_	
aa. Less than $1\frac{1}{4}$ " or more than $1\frac{3}{8}$ ".	77	X	
bb. 1 1/8" or less.	X		
(2) Second loop		v	
aa. Less than 1" or more than 1 1/8". bb. 7/8" or less.	X	X	
00. 7/8 OI 1035.	Λ		

TABLE VI DETAIL DEFECTS			
	CLASSI	FICATI	ON
	MAJOR		IOR
40. 40. 40. 40.		A	В
12. ARMHOLES			
 a. Armhole stretched b. Armhole taped too tightly, causing puckering around armhole seam, affecting appearance. c. Armhole seam crooked, affecting appearance. d. Armhole not tacked completely. e. Unsightly felling or tape stitching of armhole exposed and visible on outside surface, affecting appearance. f. Sleeve-head pad not completely tacked to armhole or misplaced tacking to far away from the armhole seam causing an indentation across top of sleeve, affecting appearance. 13. SLEEVES (CONTINUED) 	*	X X X	X
 a. Setting and hang Sleeve fullness misplaced. Sleeve too far front, i.e., front edge of sleeve more than 1 ½" forward from center of lower pocket flap button. Sleeve too far back, i.e., front edge of sleeve more than 1 ½" back from cent of lower pocket flap button. Hang of sleeves in opposite directions, i.e., one sleeve too far forward and one sleeve too far back, tolerance of 1" from center of lower pocket flap button for position of each sleeve. Sleeve tight in armhole, i.e., roll effect not present on front or back of sleeve. Sleeve back seam unequal distance from shoulder seams (outside) aa. More than ½" but not more than ¾". bb. More than ¾" 	* X X X	X X	
 b. Sleeve lining Lining twisted, tight, or short, causing, bulge, twist, or puckering on outside of sleeve. Sleeve lining too long, causing lining to sag at bottom more than ½" from felled edge of lining. Sleeve lining seam out of alignment more than ¾" with sleeve seam at armhole or at bottom of sleeve. 	*	X	X

TABLE VI DETAIL DEFECTS			
	CLASSI	FICATI	ON
	MAJOR	MIN	
		A	В
c. Construction of sleeves			
(1) Sleeve bottom interlining (wigan) twisted, tight or pleated,			
causing ridges or puckering on outside of bottom of sleeve,		3.7	
affecting appearance.		X	
(2) Tacking on bottom turn-up to sleeve bottom interlining (wigan) omitted or insecure.		v	
(3) Sleeve bottom edge uneven		X	
aa. More than ¹ / ₄ " but not more than 3/8".			X
bb. More than 3/8".		X	71
(4) Tacking on one or both sleeve lining seams to sleeve seams			
omitted, insecure, or not extending to within 5" from top or			
bottom edge.			X
d. Braid on sleeves			
(1) Bottom edge of braid less than 2 7/8" or more than 3 1/8" from			
bottom of sleeves.		X	
(2) Not joined evenly in back arm seam. aa. More than 1/8" but not more than 3/16".			X
bb. More than 3/16"		X	Λ
bb. Wide than 3/10		Λ	
14. FRONT BUTTONHOLES (POSITION)			
a. Buttonhole finished with purling on the reverse side.	X		
b. Buttonhole less than ½" but not less than 3/8" or more than ¾" but not more			
than 7/8" from edge.		X	
c. Buttonholes less than 3/8" or more than 7/8" from edge.	X		
d. Buttonholes unevenly spaced from edge			
(1) $1/8$ " or more, but not more than $1/4$ "		X	
(2) More than ¹ / ₄ "	X	37	
e. Buttonholes more than ¹ / ₄ " from equal spacing.		X	
f. Lower front buttonhole from top edge of lower left flap (1) Less than 3/4" but not less than 1/2" inch or more than 1" but not			
(1) Less than $\frac{7}{4}$ but not less than $\frac{7}{2}$ linch of more than 1 but not more than 1 $\frac{1}{4}$.		X	
(2) Less than $\frac{1}{4}$ or more than $1\frac{1}{4}$.	X	Λ	
(2) 2000 main /2 or more main 1 /4 .	21		
15. FRONT BUTTONS (POSITION)			
a. Buttons less than 1 5/8" but not less than 1 3/8" or more than 1 7/8" but not			
more than 2" from edge.			X
b. Buttons less than 1 3/8" or more than 2" from edge.		X	21
c. Buttons out of vertical alignment		2.	
(1) ½" or more but not more than 3/8"		X	
(2) more than 3/8".	X		

TABLE VI DETAIL DEFECTS			
	CLASSI	FICATI	ON
	MAJOR		IOR
	77	A	В
d. Buttons stitching not caught though front interlining on one or more buttons.	X		
e. Button stitching caught through front interlining on one or more buttons. (1) One button			X
(2) Two or more buttons		X	
16. YOKE (BACK VIEW)			
Yoke tight, short, or twisted, causing fullness or twists on outside of coat.	*		
17. VENT OPENING			
 a. Left vent edge stretched, causing vent to spread open, affecting appearance. b. Diagonal row of stitching across top of vent opening omitted or insecure. c. Diagonal row of stitching across top of vent opening stitched for a distance of ½" or less. 		X X	X
d. Stay piece at top of vent opening omitted or not positioned on right back.e. Left vent 3/16" or more, shorter than right vent.		X X	v
 f. Left vent ¼" or more, longer than right vent. g. Left vent edge crooked, affecting appearance. h. Binding on left vent tight, causing puckering on outside of left vent, 		X	X
affecting appearance (class 1 only). i. Right vent lining tight, short, or twisted, causing fullness or twist on outside		X	
of tight vent, affecting appearance. j. Bottom turn-up exposed and visible on left vent edge.		X	X
18. VERTICAL POSITION OF THE LEFT FRONT			
 a. Left front edge off the line perpendicular to the plane of the horizontal by more than 1/2", but not more than 1", measured front the top buttonhole to the bottom corner at the left front. b. Left front edge off the line perpendicular to the plane of the horizontal by more than 1", measured from the top buttonhole to the bottom corner of the left front. 	X	X	
19. BREAST POCKETS (TACKING)			
One or both corners of stay piece of breast pockets not tacked or not securely tacked to the interlining.			X

TABLE VI DETAIL DEFECTS			
	CLASSI	FICATI	ON
	MAJOR	MIN	IOR
		Α	В
20. FRONT WAIST DART (CONSTRUCTION AND TACKING)			
a. Waist dart seam not pressed open.b. Tacking of waist dart seam to interlining omitted or insecure.		X	X
INSIDE OF COAT (SPREAD ON TABLE)			
21. SIZE LABEL			
a. Size label missing, incorrect, or illegible.b. Size label not securely caught in stitching.c. Size shown on size label not in conformance with size shown on intermediate or outer container as applicable.		X X	X
22. HANGER			
 a. Hanger omitted or ends not securely stitched. b. Hanger less than 1 ½" but not less than 1 ¼" or more than 2 ½" long. c. Hanger less than 1 ¼" long. 		X X	X
23. FRONT FACINGS			
a. Fullness on facing between buttons, buttonholes, or between front edged and buttons or buttonholes.b. Tacking of back edge to one or both interlinings omitted.		X	X
c. Tacking of back edge to interlining insecure or incomplete for a distance of more than 1 ½" below shoulder seam, more than 2 ½" above pocket opening or more than 2" above bottom of coat.			X
d. Tacking of front facing caught through pocket twill cloth, breast pocket, or through front.		X	
e. Tacking stitches of front facing caught to front causing impression marks, affecting appearance.		X	
f. Felling on back lower corner of front facings omitted or insecure.			X

TABLE VI DETAIL DEFECTS			
	CLASSI		
	MAJOR		IOR
AA DIGIDE DDE AGT DOCKET		A	В
24. INSIDE BREAST POCKET			
a. Opening of inside breast pocket not extending into facing or extending to armhole.		X	
b. Opening of inside breast pocket extending into facings more than 1 ½".c. Twill-cloth stay piece of inside breast pocket not extending to armhole seam			X X
or not stitched to lining. d. Opening of inside breast pocket badly gapped. e. Width of opening of inside breast pocket			X
 (1) Less than 5 ½" but not less than 5". (2) Less than 5". 		X	X
f. Depth of pocket (1) Less than 6 ½" but not less than 5 ½". (2) Less than 5 ½".		X	X
g. One or both corners of pocket opening not securely tacked, puckered, or poorly finished.		X X	
h. Tacking on back upper corner of pocket to interlining		Λ	
i. Tacking along front edge of pocket through facing to interlining (1) Omitted, insecure, or not caught through interlining.		X	v
(2) Extending for a distance of less than 5 inches.			X
25. COMBINATION CONTRACTOR AND IDENTIFICATION LABEL			
a. Label missing, incorrect, or illegible.b. Label not stitched on four sides or not stitched to twill cloth of the inside breast pocket.		X	X
26. LININGS			
a. Yoke			
(1) Excessive fullness or pleats in yoke.			X X
(2) Yoke twisted not affecting smoothness on outside surface of back.(3) Center pleat omitted.		X	Λ
(4) Bottom hem less than 3/8" or more than 5/8"			X
b. Front body lining			
(1) Excessive puckering or pleats.			X
(2) Lining twisted not affecting smoothness on outside surface of fronts.			X
(3) Pleat omitted at shoulder.		X	Λ
(4) Front dart omitted.		X	
(5) Underarm dart omitted.		X	
(6) Pleat omitted along bottom or sides.		X	
(7) Felling on bottom corners omitted or insecure.			X

TABLE VI DETAIL DEFECTS					
	CLASSIFICATION				
	MAJOR	MIN	IOR		
		A	В		
c. Armhole shields					
(1) Shield placed so that front edge covers inside pocket opening 1/4"		3.7			
or more or ½" or more back of forearm seam of sleeve lining.		X			
(2) Top edge of shield not securely caught in armhole tacking and stitching.		X			
(3) Tacking omitted or insecure on lower edge of shield to lining.		Λ	X		
(4) Shield badly puckered, pleated, or twisted.		X	71		
d. Lining side of armholes					
(1) Shields placed so that front edge covers inside pocket opening 1/4"					
or more or ½" or more back of forearm seam of sleeve lining.			X		
(2) Matching tacking omitted at base of armhole from front sleeve					
notch to side seam when armhole is tacked by hand.		X			
(3) Sleeve lining not felled at armpit.			X		
e. Right vent lining (1) Top edge of right bent lining not completely covering edges of					
center seam outlets.		X			
(2) Lining irregular in width by more than ½".		71	X		
(3) Vent lining not doubled when seamed to edge.		X			
27. CORNERS OF VENT OPENING					
27. CORNERS OF VENT OF ENING					
a. Felling omitted or insecure on one or both cornets of the vent opening.		X			
28. BINDING ON SEAM OUTLETS, EDGE, AND BOTTOM OF COAT					
ACROSS BACK					
a. Felling omitted or insecure on one or both corners of the vent opening.	*				
b. Binding tight, causing edge of seam outlets to curl and not lie flat.		X			
c. Binding tight, on bottom hem, causing puckering on outside of coat, affecting		X			
appearance.					
d. Blind stitching on turned-under edge on one or more seam outlet			v		
(1) Omitted or insecure for a distance of 1".(2) Omitted or insecure for a distance of more than 2".		X	X		
(2) Offitted of fiscoure for a distance of filore than 2.		Λ			
29. BOTTOM HEM AND TURN-UP					
			v		
 a. Hem on back part twisted or irregular in width by ½" or more. b. Tacking on turn-up of fronts omitted or insecure. 		v	X		
b. Tacking on turn-up of fronts omitted or insecure.		X			

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- 4. 10 <u>Finished Measurement Defects.</u> Any finished measurement deviation from the finished measurements specified in Table IV shall be classified as a defect. Sleeve lengths uneven by ½" or more shall be classified as a defect see Table V and Table VI.
- 4. 10. 1 Examination of Preparation for Delivery Requirements. An examination shall be made to determine if packaging, packing, and marking requirements have been met. The sample unit shall be one shipping container fully packed and selected just prior to the closing operation. The lot size shall be the number of containers in the inspection lot. The inspection level shall be S-3 of ANSI Z1.4, and the acceptable quality level shall be 4.0 defects per 100 units. Shipping containers full prepared for delivery shall be examined for defects of closure and scored as follows:

$\frac{\text{TABLE VII PACKAGING AND SHIPPING DEFECTS}}{\text{EXAMINE}} \\ \underline{\text{DEFECT}}$

Marking Omitted; incorrect, illegible or improper size, location,

sequence, or method of application.

Materials Any component missing. Any component damaged,

affecting serviceability.

Workmanship Inadequate application of component such as: incomplete

closure of case liners or inadequate stapling. Bulging or

distortion of containers.

Content Number of intermediate packages is more or less than

required.

5. PREPARATION FOR DELIVERY

5.1 Packaging

- 5. 1. 1 Level <u>A.</u> Each coat shall be laid back down. The buttonhole front shall overlap the button front. The sleeves shall be positioned full length so that the ends of the sleeve rest over the pockets. The coat shall then be folded in half by bringing the collar down even with the bottom edge so that the folded coat measures not more than 21" X 16". Each unit shall then be inserted in a close-fitting bag that is made of 0.003" gauge polyethylene. All seams and closures shall collected by heat sealing (see 5.3.1). Prior to or during the heat-sealing operation, excess air shall be expelled to the extent necessary to permit packaging in the intermediate container.
- 5. 1. 2 <u>Level B.</u> Five folded coats of one size only, stacked one on another and alternated collar to bottom, shall be placed in a box conforming to type, CF, class domestic, style FTC of ASTM-D1974. The minimum bursting strength of the fiberboard shall be 200 pounds per square inch (psi). The inside dimensions of the box shall be approximately 21" in length, 16" in width, and 6" in depth. The box closure shall be secured with gummed tape that is a minimum of 3" in width. The tape shall be applied at the center of the length opening and shall extend along the bottom and up the sides of the box at least 3".
- 5. 1. 3 <u>Level C.</u> Coats will be packaged to afford adequate protection against damage during shipment from the supply source to the first receiving activity. The supplier may use his standard practice when it meets this requirement.

USAFA CU 120-09 30 December 2002 SUPERSEDING USAFA CU 120-09 10 Jun 1994 5.2 Packing

- 5. 2. 1 <u>Level B.</u> Fifteen individual coats shall be packed in a commercial cardboard stand-up hanger pack type box made specifically for shipment of garments on hangers. The hangers shall be secured onto the hanging rod to prevent their coming off during shipment. All flaps shall be securely sealed with metal stitching, tape, or a commercial adhesive. As far as practicable, coats of one size only shall be packed in containers which, together with packaging, wrapping and inner packing, conform to carrier rules and regulations as applicable to the mode of transportation selected.
- 5. 3 Marking. In addition to any special marking required by the contract or order, interior packages and shipping containers shall be marked in accordance with MIL-STD-129.
- 5. 3. 1 <u>Polyethylene Packages.</u> The stock number, the nomenclature, the size, and the quantity of coats shall be legibly printed or stamped in black directly on the bag or on a white paper label that is inserted in the bag so that the information readable through the bag.
- 5. 3. 2 <u>Mixed Sizes.</u> Each shipping container packed with mixed sizes (see 5.2.1) shall have a white paper label, 5" by 4", securely attached to the end and side. The word mixed sizes shall be printed on the label, and under these words shall be legibly printed the quantity and sizes of coats contained therein.
- 6. NOTES
- 6. 1 <u>Intended Use.</u> The coat covered by this specification is intended for use as a component of the dress uniform worn by the Cadet personnel of the United States Air Force Academy.
- 6.2 Figures. The figures numbered 1 and 2 are for visual information only. Figures 3 are for "Finished Measurement inspections.
- 6.2 Ordering Data.

Procurement documents should specify the following:

- a. Title, number, and date of this specification.
- b. Class and size required (See 1.2 & 1.2.1)
- c. Availability of sample (See 3.1)
- d. Requirements for pre-production sample (See 3.2.1)
- e. Selection of applicable packaging, packing and marking requirements specified herein (See 5.1, and 5.3).

<u>CUSTODIAN:</u> USAF Academy, CO 80840-8210 PREPARING ACTIVITY:
Quality Control Section (34TRW/SDCU)
USAF Academy, CO 80840-8210

REVIEWING ACTIVITY:
Director, Cadet Support Branch (34TRW/SD)
USAF Academy, CO 80840-8210

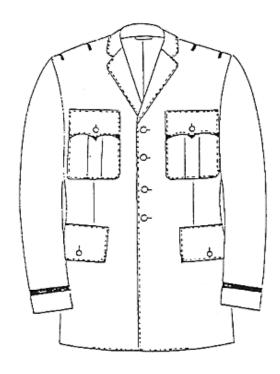


FIGURE 1. Coat (Front View)

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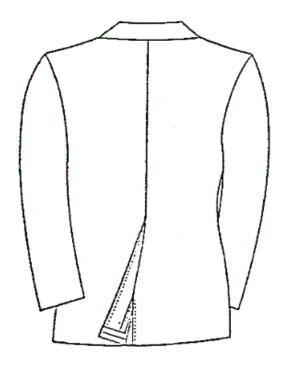


FIGURE 2. Coat (Back View)

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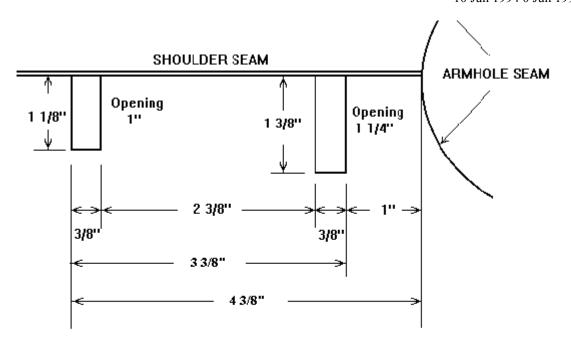


Figure 3. Shoulder Loop Placement

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